

Work Order ID 59160

Thursday, May 27, 2010 9:23:33 AM



Page 1

Item ID: D2435

Accept



Setup Start



Revision ID:

Item Name: Bearpaw, 206

Stop



Start Date: 5/27/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B 10-67



130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

[Signature] 10/06/09

9

8

- 1-Inspect material for defects or damage prior to machining
- 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
- 3-Deburr

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

[Signature] 10/06/10

9

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 <i>MV=</i> 0.00		10/06/10		9	9		
151 Packaging Packaging	Identify as per dwg & Stock Location: <i>PAP</i> Memo	0.00 0.00							
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

58476 *Perf/11*
(8)

1XSTUNE

10/06/14 *[Signature]*
C2101611

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Picklist Print

Thursday, May 27, 2010 9:23:37 AM

Page 1

Work Order ID: 59160



Parent Item: D2435

Parent Item Name: Bearpaw, 206

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	428.7000	3.2	25.6			



UHMW 1" Black



B10-6-7

Location

Loc Qty

Loc Code

MAT

428.7

112186

20.7

113903

88

114624

320

114624

④

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DART AEROSPACE LTD		Work Order:	59160
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.057x45°	—			
B	5.500	+/-0.030	5.509	—			
C	0.200	+/-0.030	.190	—			
D	R0.250	+/-0.030	R.250	—			
E	0.250	+/-0.010	.248	—			
F	0.625	+/-0.030	.632	—			
G	0.25 x 45°	+/-0.030	.265x45°	—			
H	0.375	+/-0.010	.370	—			
I	19.000	+/-0.030	19.000	—			
J	0.950	+0.030/-0.010	.953	—			
K	Ø0.260	+0.005/-0.000	Ø.260	—			
L	Ø0.930	+/-0.030	Ø.927	—			
M	0.30	+0.030/-0.000	.310	—			
N	0.375	+/-0.030	.380	—			
O	7.375	+/-0.030	7.375	—			
P	4.250	+/-0.010	4.250	—			
Q	2.000	+/-0.030	2.000	—			
R	9.000	+/-0.010	9.000	—			
S	15.750	+/-0.030	15.750	—			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10/06/10	Date:	10/06/10	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WY</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

RELEASED
98.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE DEOS

9143

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

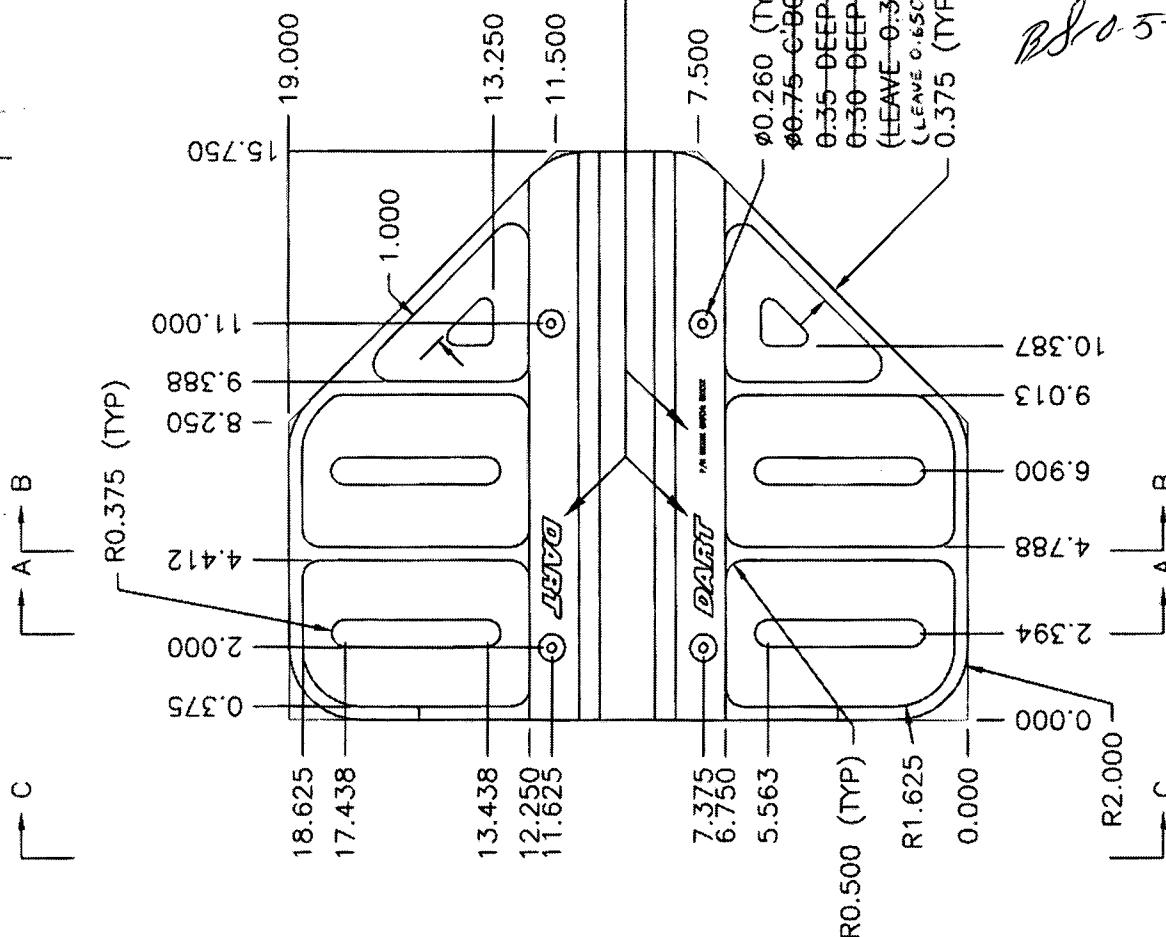
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 39160

28-05-27



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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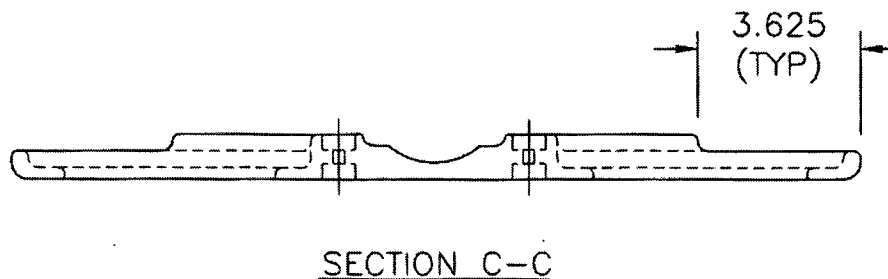
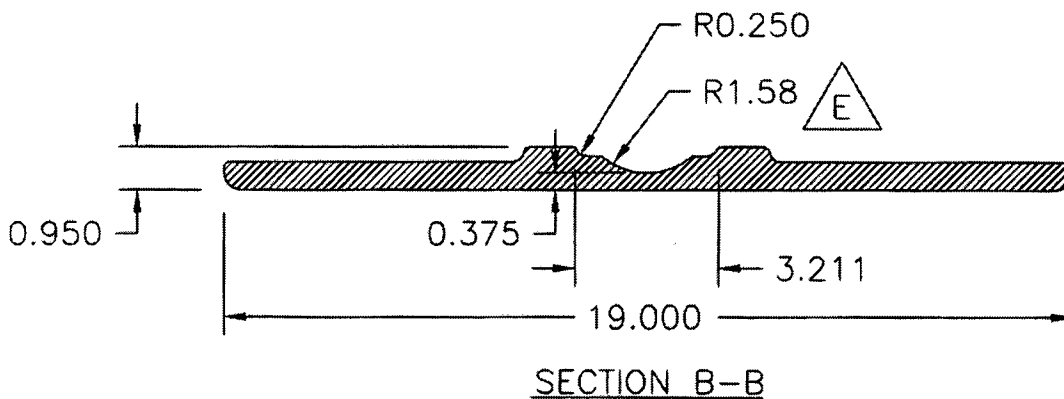
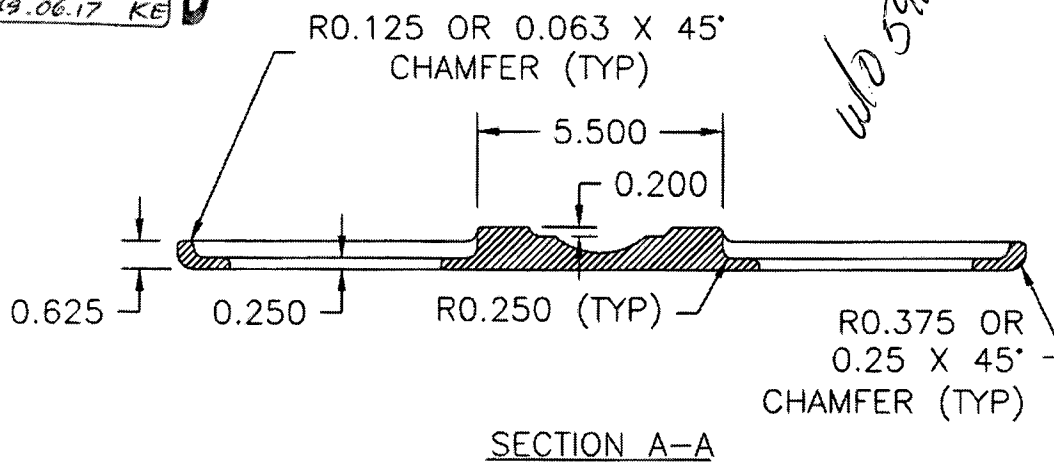
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CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



W/O:		WORK ORDER CHANGES					
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